

Work Order ID 60967

Tuesday, August 03, 2010 8:59:18 AM



Page 1

Item ID: D4032-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Short Basket Assembly, Light Lid (350)

Start Date: 8/3/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 8/10/2010 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: cmf Date: 10-8-03 Tooling:

Date:

Stop



QC: Date: SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4032

C

U/R

PROCEED PER

HAND CHANGES

10.08.04

100

Pick Kit



Packaging

Memo

0.00

Packaging

EP 10/08/10 @

110

Assemble as per dwg



HandFinish

Memo

0.00

Hand Finishing

0.00

EP 10/08/10 @

120

QC5- Inspect part completeness to step on W/O



QC

Memo

0.00

Quality Control

0.00

Siobhán

QO

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D4032-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Short Basket Assembly, Light Lid (350)

Start Date: 8/3/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 8/10/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00

PP 61030



Packaging

used on w/b 61030

Memo

0.00

Packaging

D38-607-447

10/6/10 SP

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/11 AJ

U 10-08-11

W/O:		WORK ORDER CHANGES						
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Picklist Print

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Work Order ID: 60967

Parent Item: D4032-043

Parent Item Name: Short Basket Assembly, Light Lid (350)




Start Date: 8/3/2010

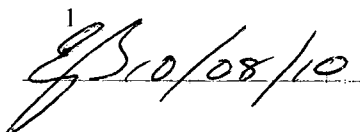

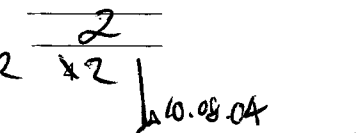
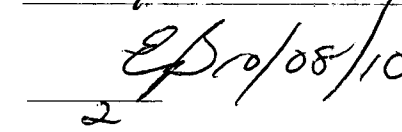
Required Date: 8/10/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC IPP Rev:B as
per dwg revC DD 10.04.20 verified by:EC IPP Rev:C added
NAS1149F0332P, NAS1149F0563P & NAS1149C0432R 10.06.16 DD
VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2530  Handle Weldment		Manufactured	No			100	Each	12.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
ST506 12													
59637 2													
60206 10													
D2535  Spring		Manufactured	No			100	Each	92.0000	2	2			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
ST504 92													
58331 92													
D2537  Bushing		Manufactured	No			100	Each	45.0000	2	2			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
ST504 45													
58429 9													
59122 20													
59423 16													

W/O:		WORK ORDER CHANGES						
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Page 2

Work Order ID: 60967

Parent Item: D4032-043

Parent Item Name: Short Basket Assembly, Light Lid (350)

Start Date: 8/3/2010

Required Date: 8/10/2010

Start Qty: 1.00

Required Qty: 1.00

D3917-3
Washer
Manufactured No 100 Each 7.0000

6 6



EP 8/10/08/10

Location Loc Qty Loc Code

ST095 6

60298 6

ST096 1

57144 1

D3953-3
Gas Spring Stud, Lid
Manufactured No 100 Each 16.0000

2 2



EP 8/10/08/10

Location Loc Qty Loc Code

ST102 16

59437 16

D3953-7
Spring Spacer
Manufactured No 100 Each 16.0000

2 2



EP 8/10/08/10

Location Loc Qty Loc Code

ST103 16

59438 16

D3953-9
Gas Spring Washer
Manufactured No 100 Each 28.0000

2 2



EP 8/10/08/10

Location Loc Qty Loc Code

ST101 8

53642 2

59147 6

ST103 20

60008 20

2

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Shop Packet Print

Page 2

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Page 3

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Parent Item: D4032-043

Parent Item Name: Short Basket Assembly, Light Lid (350)

Start Date: 8/3/2010

Required Date: 8/10/2010

Start Qty: 1.00

Required Qty: 1.00

D3953-17
Gas Spring Spacer
Manufactured No 100 Each

22.0000 2 2



EB 10/08/10

Location

Loc Qty

Loc Code

ST101

22

57143

1

59197

21

D3953-19
Gas Spring Bracket
Manufactured No 100 Each

13.0000 1



EB 10/08/10

Location

Loc Qty

Loc Code

ST

13

59213

13

D3953-21
Gas Spring Bracket
Manufactured No 100 Each

21.0000 1



EB 10/08/10

Location

Loc Qty

Loc Code

ENG

5

56407

5

ST102

16

57145

2

59214

14

D3969-3
Spring (Basket Lid)
Manufactured No 100 Each

6.0000 1



EB 10/08/10

Location

Loc Qty

Loc Code

ST

6

56386

1

58986

5

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Page 3

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Tuesday, August 03, 2010 8:59:17 AM

Page 4

Work Order ID: 60967

Parent Item: D4032-043

Parent Item Name: Short Basket Assembly, Light Lid (350)

Start Date: 8/3/2010

Required Date: 8/10/2010

Start Qty: 1.00

Required Qty: 1.00

D4017-041 Manufactured No

100 Each 0.0000 1



Short Basket Base Assembly (350)

B60969 (1X)



Ep 10/08/10

D4019-041 Manufactured No

100 Each 0.0000 1



B60968 (1X)



Ep 10/08/10

Light Lid Short Basket Assembly

AN3-14A Purchased No

100 Each 110.0000 4



Bolt



Ep 10/08/10

Location

Loc Qty

Loc Code

ST351

110

114330

10

114941

50

115108

50

4

AN3-20A Purchased No

100 Each 34.0000 2



Bolt



Ep 10/08/10

Location

Loc Qty

Loc Code

ST352

34

105125

34

2

AN4-12 Purchased No

100 Each 43.0000 3



Bolt



Ep 10/08/10

Location

Loc Qty

Loc Code

ST357

43

114292

2

114784

41

3

Tuesday, August 03, 2010 8:59:17 AM

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Page 4

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 5

Work Order ID: 60967



Parent Item: D4032-043



Parent Item Name: Short Basket Assembly, Light Lid (350)

Start Date: 8/3/2010

Required Date: 8/10/2010

Start Qty: 1.00

Required Qty: 1.00

AN5-17A Purchased No 100 Each

92.0000 2



Bolt

Ep 8/08/10

Location

Loc Qty

Loc Code

ST339

92

114330

46

114784

46

2

AN5-21A Purchased No 100 Each

58.0000 2



Bolt

Ep 8/08/10

Location

Loc Qty

Loc Code

ST339

58

114714

50

16463

8

2

AN310-4 Purchased No 100 Each

43.0000 3



NUT

Ep 8/08/10

Location

Loc Qty

Loc Code

ST324

43

115107

43

2

AN310C4 Purchased No 100 Each

43.0000 2



Nut

Ep 8/08/10

Location

Loc Qty

Loc Code

ST349

43

114306

43

2

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Page 5

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Tuesday, August 03, 2010 8:59:17 AM

Page 6

Work Order ID: 60967

Parent Item: D4032-043

Parent Item Name: Short Basket Assembly, Light Lid (350)

Start Date: 8/3/2010

Required Date: 8/10/2010

Start Qty: 1.00

Required Qty: 1.00

MS21042L3 Purchased No 100 Each 2,466.000 6 6
Nut

Location

Loc Qty

Loc Code

ST300

2466

114523

115

114718

351

114784

2000

MS21042L5 Purchased No 100 Each 764.0000 4 4
Nut

Location

Loc Qty

Loc Code

ST139

264

114813

264

ST300

500

115156

500

MS24665-151 Purchased No 100 Each 624.0000 3 3
Cotter Pin

Location

Loc Qty

Loc Code

ST309

624

17566

624

MS24665-300 Purchased No 100 Each 54.0000 2 2
Cotter Pin

Location

Loc Qty

Loc Code

ST309

54

105279

2

110123

52

Tuesday, August 03, 2010 8:59:18 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Tuesday, August 03, 2010 8:59:18 AM

Page 7

Work Order ID: 60967

Parent Item: D4032-043

Parent Item Name: Short Basket Assembly, Light Lid (350)

Start Date: 8/3/2010

Required Date: 8/10/2010

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0432P Purchased No 100 Each

212.0000 6 6



Washer



Ep 8/08/10

Location

Loc Qty

Loc Code

ST275	212
112940	92
114405	1
114576	10
114718	109

NAS1149C0432R Purchased No 100 Each

708.0000 2 2



Washer



Ep 8/08/10

Location

Loc Qty

Loc Code

ST297	708
114292	118
114742	590

NAS1149F0332P Purchased No 100 Each

619.0000 8 8



WASHER



Ep 8/08/10

Location

Loc Qty

Loc Code

ST275	619
18057	619

NAS1149F0563P Purchased No 100 Each

200.0000 4 4



Washer



Ep 8/08/10

Location

Loc Qty

Loc Code

ST275	2
108471	2
ST298	198
114576	198

Tuesday, August 03, 2010 8:59:18 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

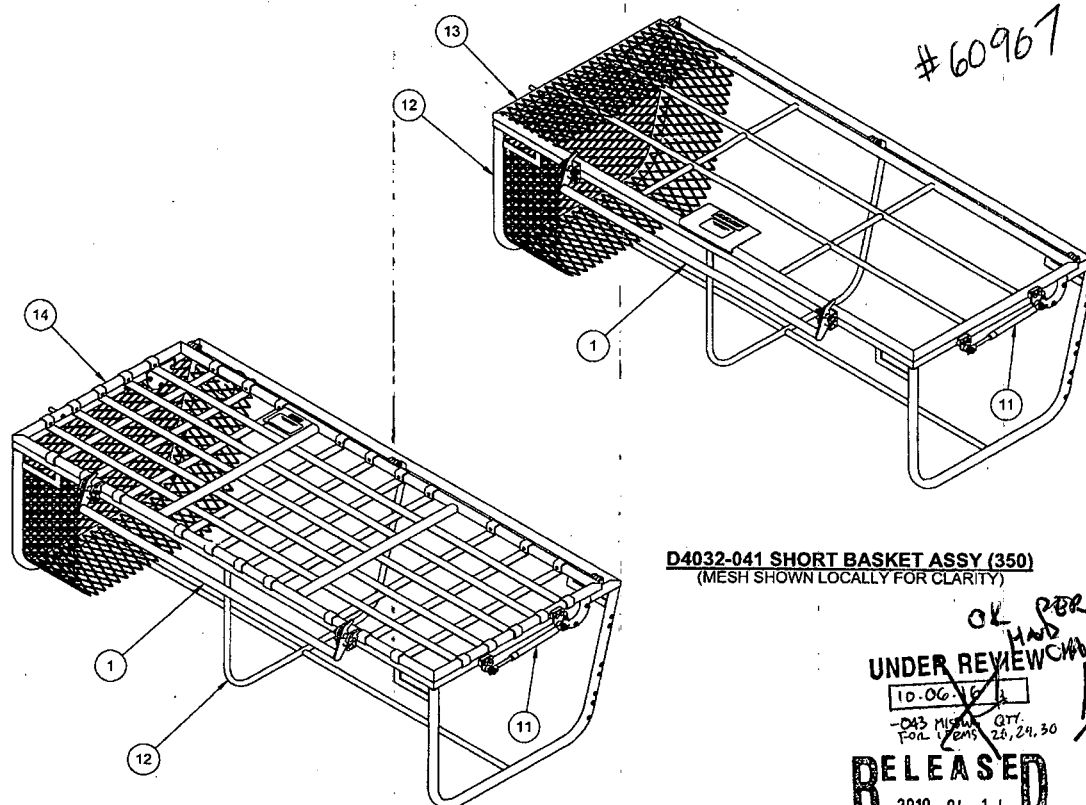
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NOTE: Date & initial all entries

ITEM	-041 QTY.	-043 QTY.	P/N	DESCRIPTION
	X		D4032-041	SHORT BASKET ASSY (350)
		X	D4032-043	SHORT BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	6	6	D3917-3	WASHER
5	2	2	D3953-3	GAS SPRING STUD, LID
6	2	2	D3953-7	GAS SPRING SPACER
7	2	2	D3953-9	GAS SPRING WASHER
8	2	2	D3953-17	GAS SPRING SPACER
9	1	1	D3953-19	GAS SPRING BRACKET
10	1	1	D3953-21	GAS SPRING BRACKET
11	1	1	D3969-3	SPRING
12	1	1	D4017-041	SHORT BASKET BASE ASSY (350)
13	1		D4018-041	SHORT BASKET LID ASSY (350)
14		1	D4019-041	LIGHT LID SHORT BASKET ASSY
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	2	2	NAS1149C0432R	WASHER
29	8	8	NAS1149F0332P	WASHER
30	4	4	NAS1149F0563P	WASHER



D4032-041 SHORT BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

D4032-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -041: 56 lbs APPROX
-043: 45 lbs APPROX

OK PER
HAB
UNDER REVIEW
10-06-10
-043 MESH QTY.
FOR LID 25, 24, 30
11-04-04
RELEASED
2010-04-14
WD

C	AN5-21A BOLT WAS AN5-18A BOLT: BOM & (D3-3)	JPH	10.04.06
B	ITEM 15 D4086-232 & 16 D4086-243 REMOVED; ITEM RENUMBERED AS REQD. PLACARDS REMOVED (C6-2); TOP VIEW DETAIL REMOVED (C2-2)	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.08
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. C
MFG. APPR.	JPH	D4032	SHEET 1 OF 3
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	SHORT BASKET ASSY (350)	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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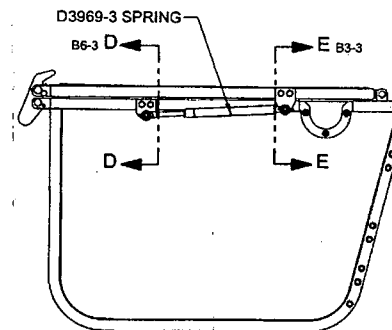
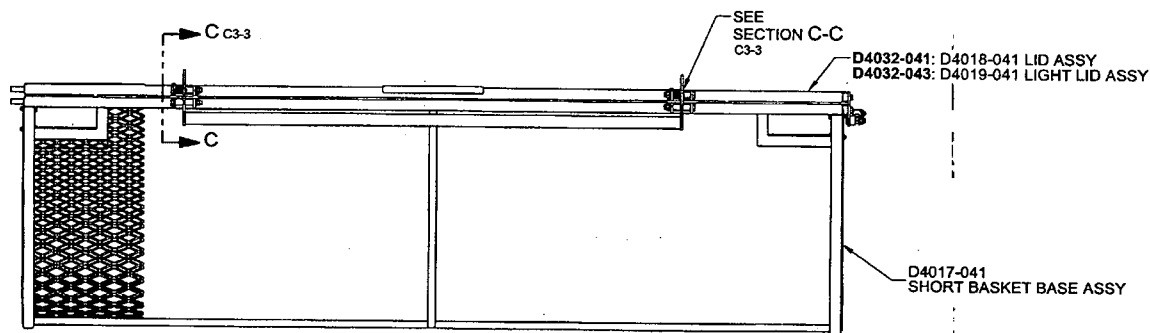
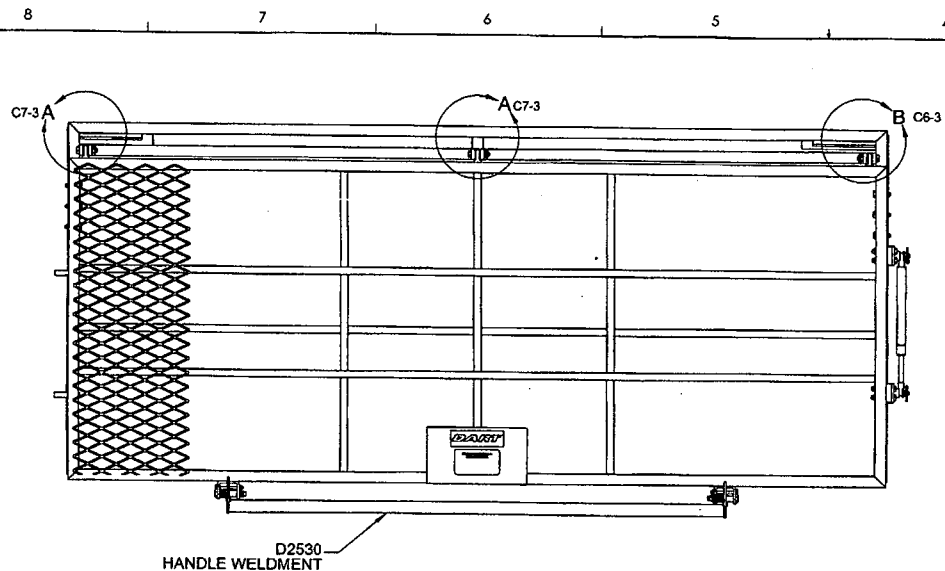
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NOTE: Date & initial all entries

#60967



D4032-041 SHORT BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)
D4032-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010-04-14
JW

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JB	D4032	SHEET 2 OF 3
APPROVED	JW	TITLE	SCALE
DE APPR.	JW	SHORT BASKET ASSY (350)	
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

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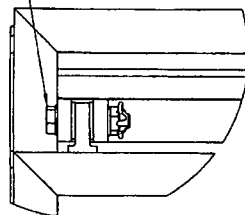
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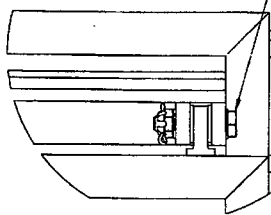
NOTE: Date & initial all entries

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



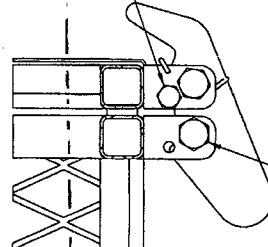
DETAIL A D8-2
D6-2

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



DETAIL B D4-2

D4032-041: AN3-16A BOLT
MS21042L3 NUT
D4032-043: AN3-20A BOLT
MS21042L3 NUT



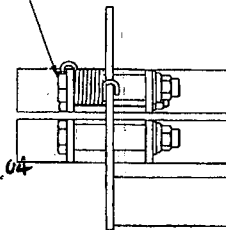
SECTION C-C B5-2
B7-2

D4032-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

D4032-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563F WASHER
MS21042L5 NUT

AN5-17A BOLT
~~D2537 BUSHING~~
NAS1149F0563P WASHER
MS21042L5 NUT

D2530 WELDMENT
REF



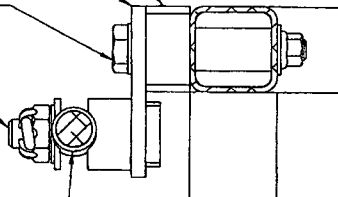
VIEW F-F C3-3

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET

AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF



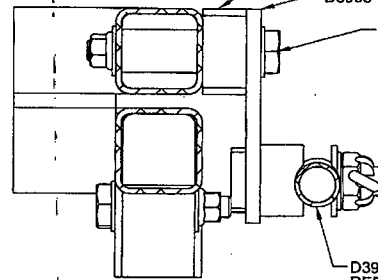
SECTION D-D B2-2

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET

AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF



SECTION E-E B1-2

RELEASED
2010-04-16

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO. D4032	REV. C
MFG. APPR.			SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET ASSY (350)	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries